

Work Order ID 148193

Thursday, July 07, 2016 1:01:32 PM

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Item ID: D4149-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Lug Plate, Aft

Start Date: 7/22/2016 Start Qty: 16.00

16

Cust Item ID:

Required Date: 7/25/2016 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4149

C

100

0.00

100

Waterjet

Memo

0.37

FLOW CNC Waterjet

Cut as per dwg D4149

Prog Rev: 2Dwg Rev: 2

OPEN TO HOLES TO FINISH SIZE AS PER DWG

Deburr as required

16

PR 2016/08/17

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.03

Quality Control

16

PR 2016/08/21

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Item ID: D4149-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Lug Plate, Aft

Start Date: 7/22/2016 Start Qty: 16.00

16

Cust Item ID:

Required Date: 7/25/2016 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.05				16	0		32 9-89
Quality Control									16.08.30
150	Identify as per dwg & Stock Location: 5686	0.00							
150									
Packaging	Memo	0.03							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.27							
Quality Control									

SEP 02 2016

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SEP 07 2016

Picklist Print

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Work Order ID: 148193

148193

Parent Item: D4149-1

D4149-1

Parent Item Name: Crosstube Lug Plate, Aft

Start Date: 7/22/2016

Required Date: 7/25/2016

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased		No		100	sf	67.8843	0.1355	2.282106			

M304S11GA

304/316 0.125 Sheet

PR 2016/08/17

Location	Loc Qty	Loc Code
MAT020	48.58998	
M129545	31.99998	
M129972	13.8	
M134284	2.79	
TPI	19.2943006	
M134604	19.2943006	

M135355

3

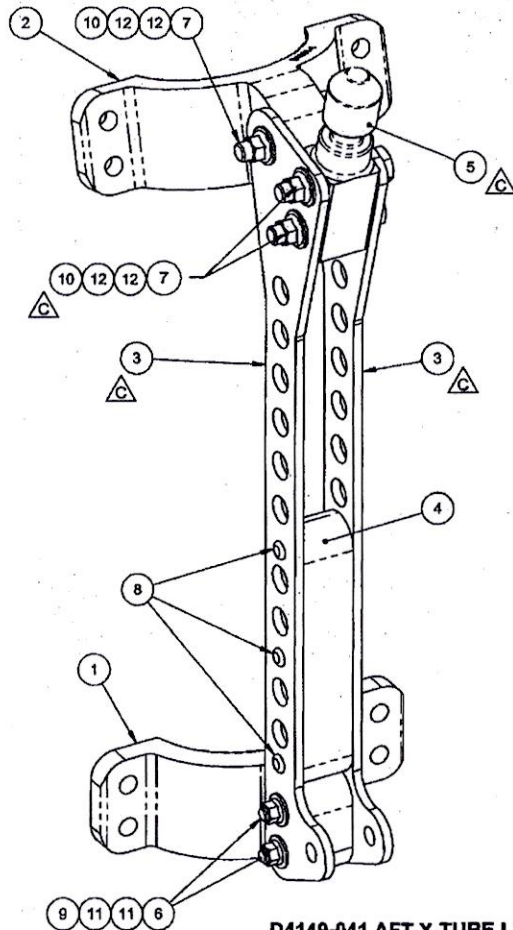
DART AEROSPACE LTD		Work Order: 148193
Description: Aft Crosstube Lug Plate		Part Number: D4149-1
Inspection Dwg: D4149	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130	✓		Dc-02	
Ø0.191	+0.005/-0.001	0.193	✓		Dc-01	
✓ Ø0.257	+0.006/-0.001	0.257	✓			
Ø0.38	+0.006/-0.001	0.381	✓			
0.380	+/-0.010	0.386	✓			
0.469	+/-0.010	0.470	✓			
0.310	+/-0.010	0.317	✓			
0.750	+/-0.010	0.757	✓			
3.25	+/-0.030	3.252	✓			
0.65	+/-0.030	0.652	✓			
0.63	+/-0.030	0.630	✓			
5.46	+/-0.030	5.462	✓			
3.80	+/-0.030	3.803	✓			
2.13	+/-0.030	2.129	✓			
1.313	+/-0.010	1.314	✓			
0.625	+/-0.010	0.628	✓			
0.375	+/-0.010	0.378	✓			
1.175	+/-0.010	1.178	✓			
0.752	+/-0.010	0.754	✓			
1.588	+/-0.010	1.590	✓			
1.587	+/-0.010	1.591	✓			
11.15	+/-0.030	11.149	✓			
0.750	+/-0.010	0.756	✓			
1.55	+/-0.030	1.554	✓			
1.12	+/-0.030	1.142	✓			
8.42	+/-0.030	8.424	✓			
2.70	+/-0.030	2.694	✓			
0.125	+/-0.010	0.116	✓			
Ø0.252	+0.003/-0.000	0.252	✓			

Measured by: PR /a	Audited by: DAS 32	Preliminary Approval:
Date: 2016/01/17	Date: 16-08-30	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	12.02.01	Dimensions updated per Dwg Rev C	KJ	



D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20815-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

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JUN 27 2016

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RELEASED
2011-02-24
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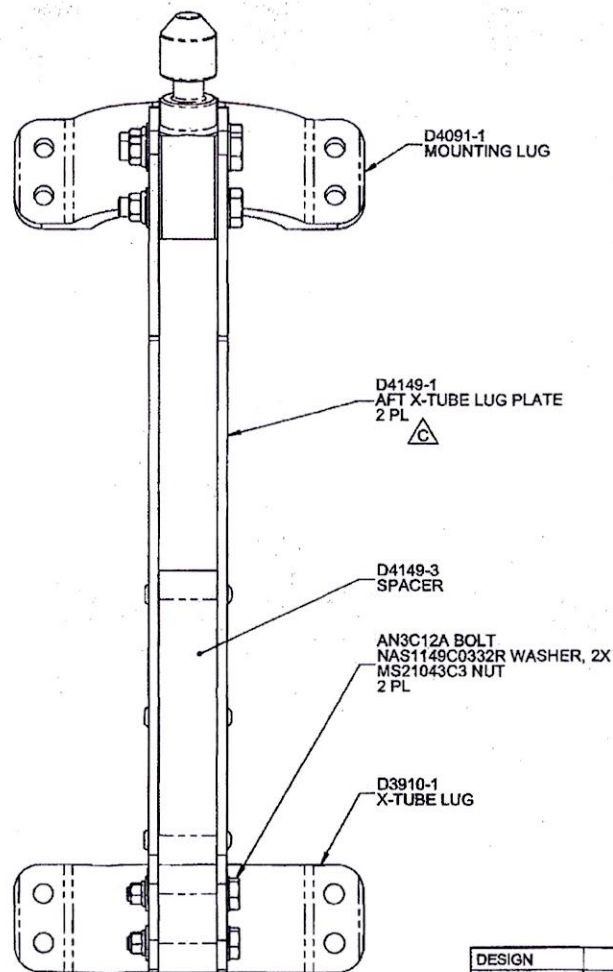
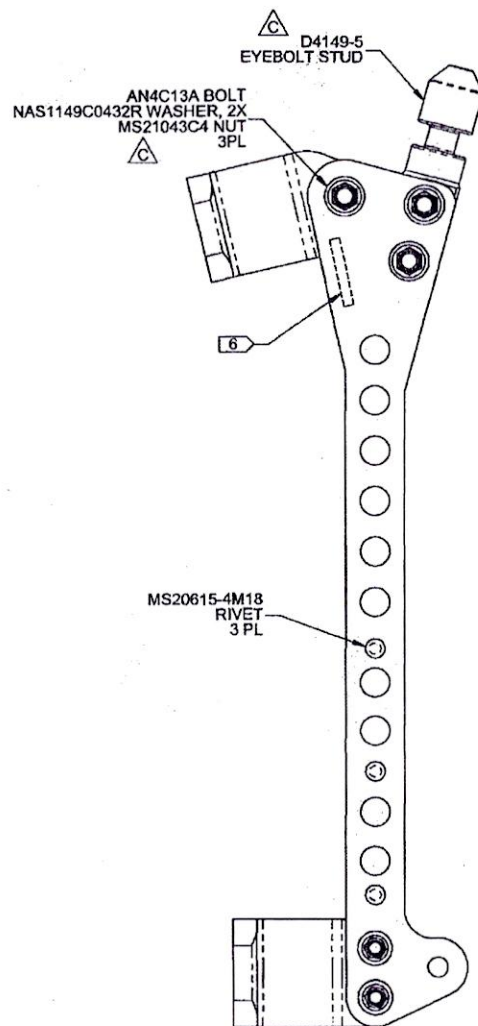
C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20815-4M18 WAS MS20815-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(5) MS20815-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4149** REV. C
SHEET 1 OF 5
TITLE **AFT X-TUBE LUG ASSY** SCALE NTS

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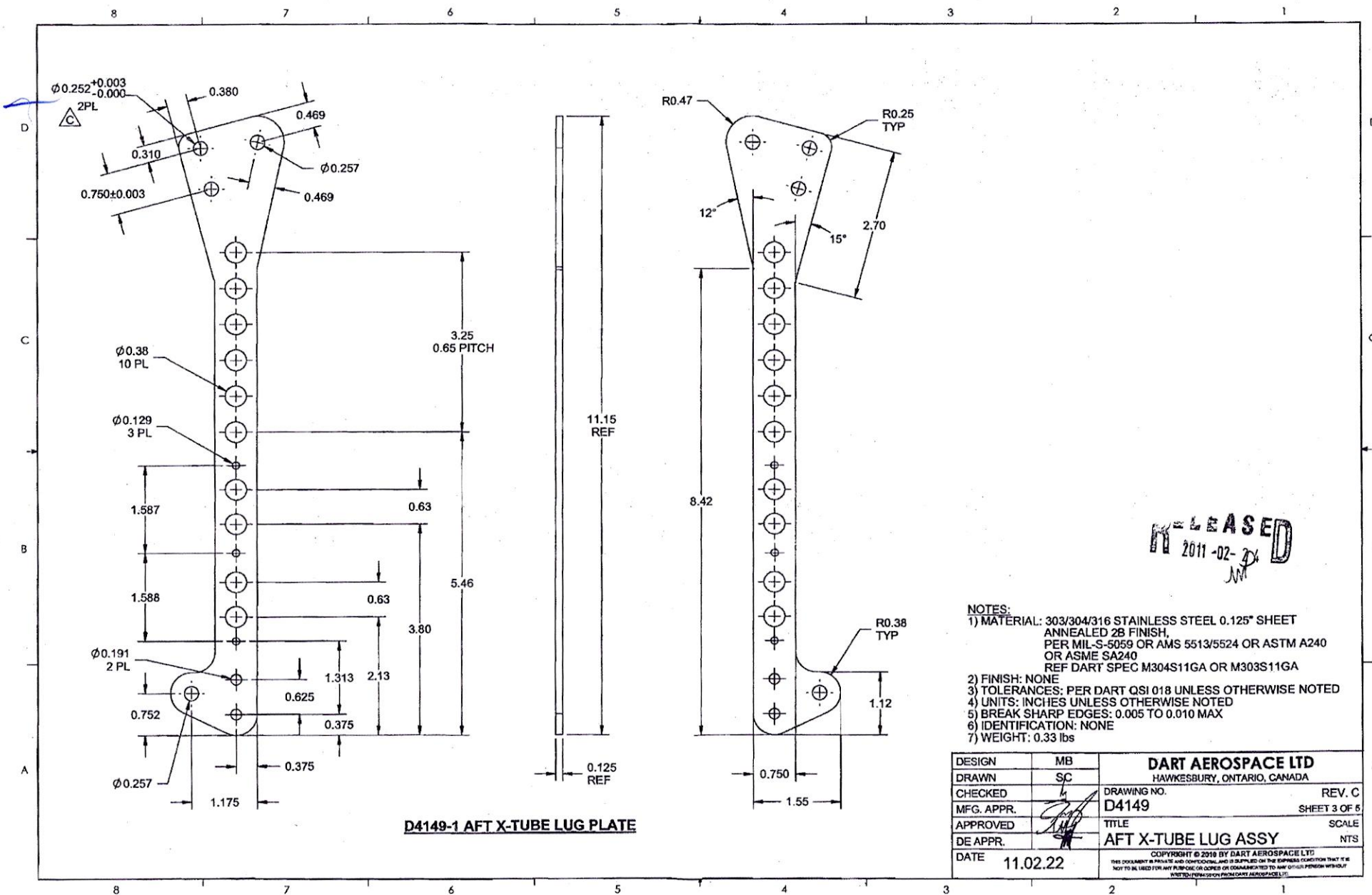


D4149-041 AFT X-TUBE LUG ASSY

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2011-02-24
MP

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HA	DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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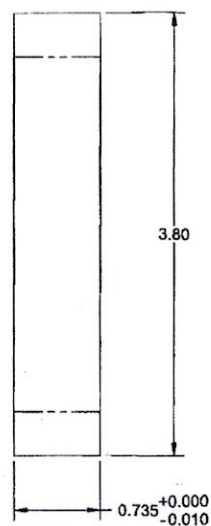
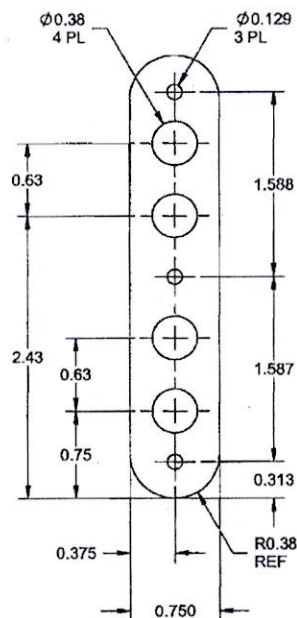
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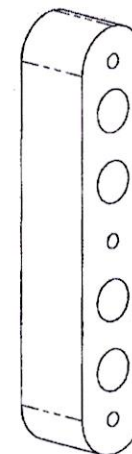
D4149-1 AFT X-TUBE LUG PLATE

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET
ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240
OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.33 lbs

DESIGN	MB	DART AEROSPACE LTD	
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MFG. APPR.		D4149	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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D4149-3 SPACER

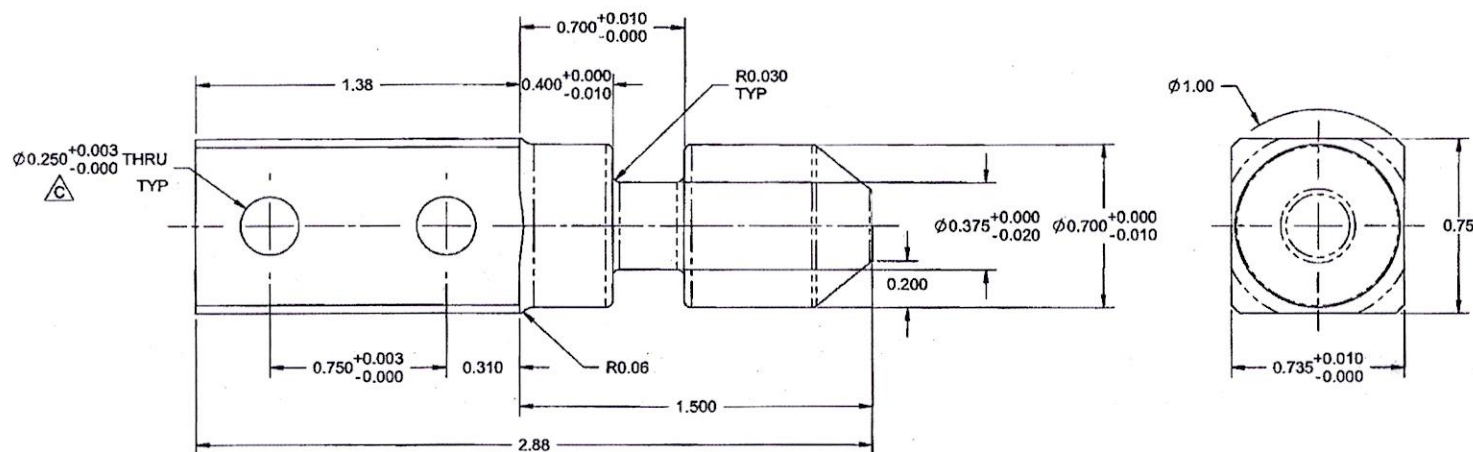


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2011-02-22

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

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MFG. APPR.		D4149	SHEET 4 OF 5
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D4149-5 EYEBOLT STUD

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2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 5 OF 5
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